



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

504/80

RBH9928-2
Job Sheet 172176



000 836
000 837

Part No: RBH9928-2

Job Qty: 3 ea

Part Name: Tab Bender with Plastic Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Due Date: 2/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBH9928-2 Rev K IPP Rev A 17.11.13 New Issue DP Verify DD/IPP Rev B 17.11.20 DWG Rev K DP
Verify DD IPP Rev.C 18.01.18 Updated process, all done under assy. JFS Verified by: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	2/17/18	2/17/18	0.00	0.00	Start Up Machining-4		MLC
100	Bandsaw	3 pcs	2/17/18	2/17/18	0.00	0.08	Bandsaw1		
110	Mori Seiki	3 pcs	2/17/18	2/17/18	0.00	1.50	MORI NV5000-1		
120	QC	3 pcs	2/17/18	2/17/18	0.00	0.00	QC2 Machining-5		
130	QC	3 pcs	2/17/18	2/17/18	0.00	0.00	QC8-7		
140	Brake NC	3 pcs	2/17/18	2/17/18	0.00	1.50	Brake NC 1		
155	QC	3 pcs	2/17/18	2/17/18	0.00	0.00	QC5		
165	Outsource	3 pcs	2/17/18	2/17/18	0.00	0.00	Outsource4		
175	Packaging	3 pcs	2/17/18	2/17/18	0.00	0.00	Packaging2		
180	QC	3 pcs	2/17/18	2/17/18	0.00	0.00	QC6		
190	Small Fab	3 pcs	2/19/18	2/19/18	0.00	1.50	Small Fab		MLC
200	QC	3 pcs	2/19/18	2/19/18	0.00	0.00	QC5		LB
210	Packaging	3 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3		DAS SMC GA
220	QC21-SA	3 Ea	2/19/18	2/19/18	0.00	0.00	QC21		21 FEB 14 2018

Part Op 100 - Cut blanks to 8.00"

Descriptions: 110 - 1-Machine RBH9928-2-1 & RBH9928-2-3 as per folio FB676 FOLIO REV: _____ DWG REV: _____

2-Deburr NOTE: ***Machine both parts at same time***

130 - Engrave T/N number ONLY (RBH9928-2) using Marktronic engraver as per DWG.

140 - -Form RBH9928-2-1 as per DWG. -Remove bending marks -Broach RBH9928-2-3 as per DWG. -Tumble to remove buffer marks

165 - -Issue P/O to ATG : PO _____ ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

190 - -Assemble as per DWG. Sheet 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S0.250X6.250	6061-T651 Sheet 0.250" Thick Plate x 6.250" Wide	1.9980 ft (.666 ea)	90-Start up Operation	
92356A247	Carriage Bolt	6 Ea (2 ea)	190-Small Fab	
96659A104	Washer	6 Ea (2 ea)	190-Small Fab	
KKT-11A	Knurled Knob	6 Ea (2 ea)	190-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition			Completed By																		
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							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
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90-Start up Operation
190-Small Fab

M6061T6S0.250X6.250
92356A247
96659A104
KKT-11A

2 7 0
6 33 0
6 83 0
6 13 0

Part Specifications

Specifications could not be found.

Plex 2/13/18 11:15 AM Dart.lajeunesse.marie

90-Start up operation - RBH9929-2-1 5032393
RBH9928-2-3 5032339

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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